

Work Order ID 74962

74962

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October 13, 2011 1:56:27 PM

Item ID: D2282-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tube
 Start Date: 10/13/11 Start Qty: 150.00 ***150*** Cust Item ID:
 Required Date: 11/15/11 Req'd Qty: 150.00 ***150*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/13 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2282	Rev E								

100 0.00
100 DOOSAN LATHE
 Doosan Memo 0.00
 Doosan Lathe 1-Turn as per Dwg D2282 and Folio FA189
 2-Deburr

154

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

154

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control

amr 11/10/13

154

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Required Date: 11/15/11 Req'd Qty: 150.00 ***150*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>WA</i>	0.00							
130									
Packaging	Memo	0.00							
Packaging	*****STOCK IN LARGE FAB*****								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

CPL 11.11.08 (154) Ø

*11/11/08 JG
ME
11-12-08*

Dart Aerospace Ltd

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Picklist Print

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Work Order ID: 74962

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Parent Item: D2282-5

D2282-5

Parent Item Name: Tube

Start Date: 10/13/11

Required Date: 11/15/11

Start Qty: 150.00

Required Qty: 150.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPPRev:B Now on Doosan Lathe 08-06-05 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304RO.750

Purchased

No

100

f

61.7430

0.18006

28.43053

M304RO 750

304 SS Roundbar .750

**

451111

Location

Loc Qty

Loc Code

MAT028

25.826

116501

1.746

116623

24.08

MAT029

35.917

117481

11.717

118509

24.2

10 Pt > 28 Pt
18 Pt

481
509
6
12

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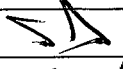
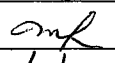
74962



DART AEROSPACE LTD		Work Order: 19773
Description: Handle Tube		Part Number: D2282-5
Inspection Dwg: D2282	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.17	+/-0.030	2.173	/			
R0.063	+/-0.010	R.063	/			
0.063	+/-0.010	.064	/			
0.125	+/-0.010	.125	/			
0.090 x 45°	+/-0.010	.090 x 45°	/			
R0.350	+0.010/-0.000	R.350	/			
0.158	+/-0.010	.161	/			
Ø0.386	+0.005/-0.000	.390	/			
Ø0.700	+/-0.010	Ø.704	/			

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 11/10/13	Date: 11/11/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Dimensions & tolerances changed	KJ/JLM	
C	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM	
D	07.11.26	Ø0.700 dimension added	KJ/EC/DD	 

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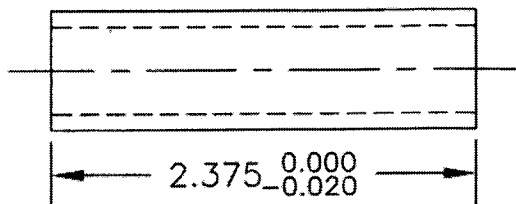
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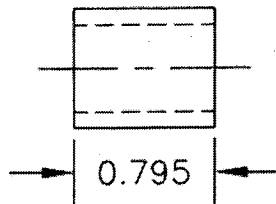
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
[Signature]

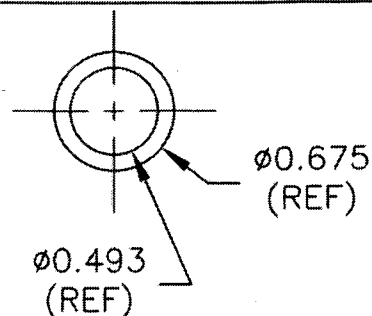
05/09/16



D2282-3

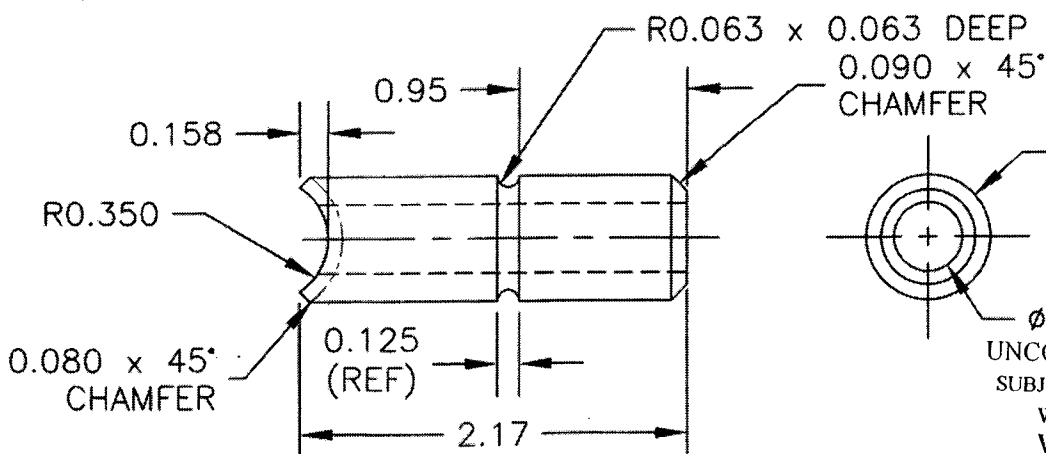


D2282-7

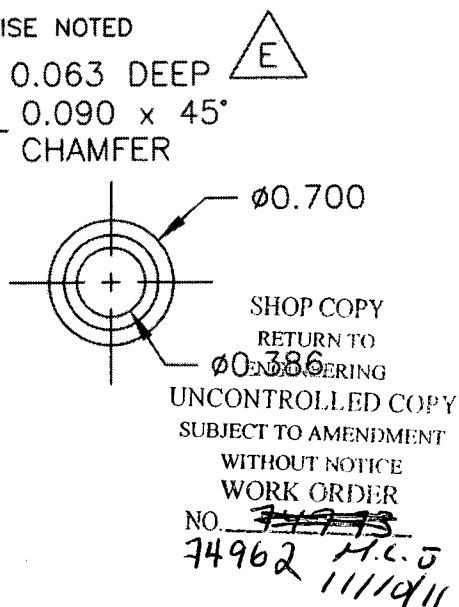


D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5



D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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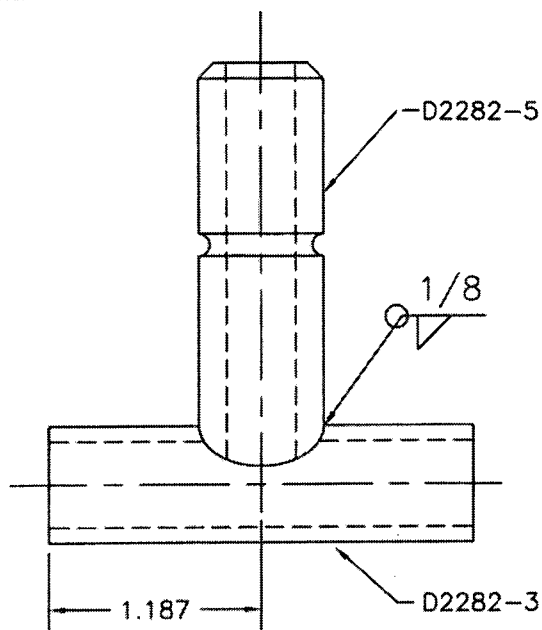
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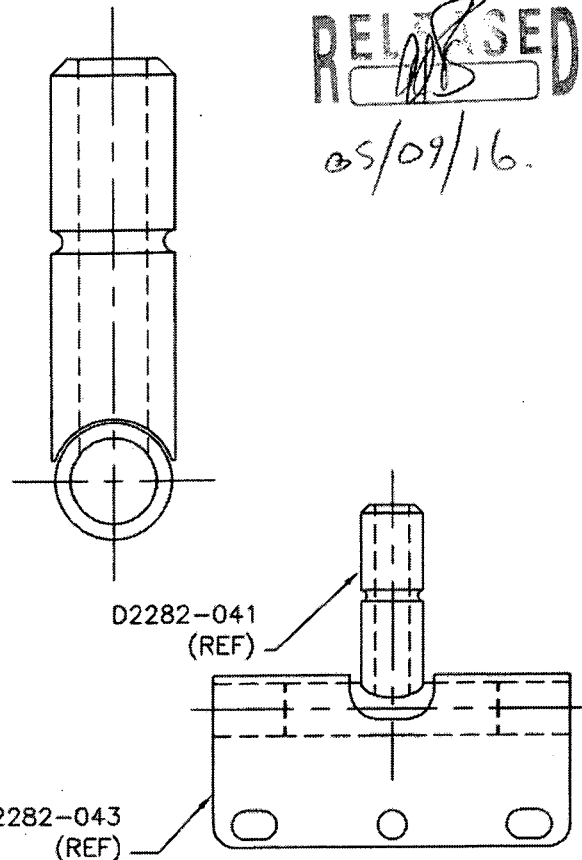
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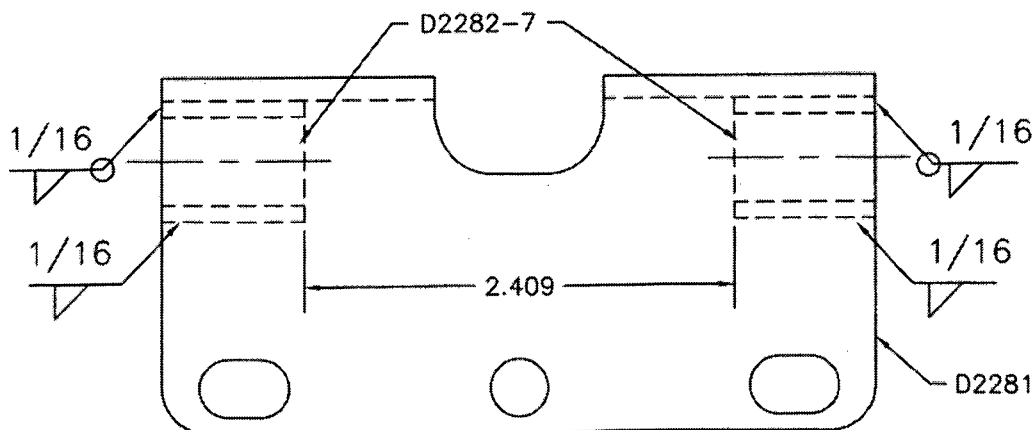
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CHECKED <i>up</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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